

# Work Order ID 66385

Monday, February 14, 2011 10:08:31 AM



Page 1

Item ID: D2939-2

Revision ID:

Item Name: Saddle RH In, 206

Start Date: 2/14/2011 Start Qty: 4.00

Required Date: 2/25/2011 Req'd Qty: 4.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan: *MF*

Date: *11-02-14*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2939

Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

HAAS CNC vertical machine #1

Memo

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

0.00

110



CONVENTIONAL MILLING MACHINE

0.00

Mill Conv

Conventional Milling Machine

Memo

Machine Keyway and inspect per attached dimension sheet

0.00

120



QC1- Inspect dimensions to dimension sheet

0.00

QC

Quality Control

Memo

*Blue*

*11.3.3*

*11.3.3*

*11.3.3*

*4*

*4*

*4*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 66385

Monday, February 14, 2011 10:08:31 AM



Page 2

Item ID: D2939-2

Accept



Setup Start



Revision ID:

Item Name: Saddle RH In, 206

Stop



Start Date: 2/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

*ml 11/03/03*



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

*=7 ml 11/03/04 (4K)*



HandFinish

Memo

0.00

Hand Finishing

145

Spray Painting per QSI005 4.2

0.00



SprayPaint

Memo

0.00

Spray Painting

Prime Delfleet Blue : B *115967*  
Paint Delfleet Blue : B *115509*  
Clear Delfleet : B *115949*

*11 03 08 (4)*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 66385

Monday, February 14, 2011 10:08:31 AM



Page 3

|                |                   |                 |  |               |       |  |
|----------------|-------------------|-----------------|--|---------------|-------|--|
| Item ID:       | D2939-2           | Accept          |  | Setup         | Start |  |
| Revision ID:   |                   |                 |  |               |       |  |
| Item Name:     | Saddle RH In, 206 |                 |  |               | Stop  |  |
| Start Date:    | 2/14/2011         | Start Qty: 4.00 |  | Cust Item ID: |       |  |
| Required Date: | 2/25/2011         | Req'd Qty: 4.00 |  | Customer:     |       |  |
| Reference:     |                   |                 |  |               |       |  |

|            |               |       |            |       |     |       |  |
|------------|---------------|-------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: | Tooling:   | Date: | Run | Start |  |
|            | QC:           | Date: | SPC (Y/N): | Date: |     | Stop  |  |

| Sequence ID/<br>Work Center ID    | Operation<br>Description                                | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number         | Insp.<br>Stamp |
|-----------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|--------------------------|----------------|
| 160<br><br>QC<br>Quality Control  | QC3- Inspect Part Finish<br><br>Memo                    | 0.00<br><br>0.00     |         |        |              |               |               | 85 11-03-09              |                |
| 170<br><br>Packaging<br>Packaging | Identify as per dwg & Stock Location: 421<br><br>Memo   | 0.00<br><br>0.00     |         |        |              |               |               | 11/3/9 SP (40)           |                |
| 180<br><br>QC<br>Quality Control  | QC21- Final Inspection - Work Order Release<br><br>Memo | 0.00<br><br>0.00     |         |        |              |               |               | 11/3/9 SP<br>CL 11/03/09 |                |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Monday, February 14, 2011 10:08:29 AM

Page 1

Work Order ID: 66385

Parent Item: D2939-2

Parent Item Name: Saddle RH In, 206


Start Date: 2/14/2011

Required Date: 2/25/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B ☐ 00.06.26 ☐ New DWG rev (mpp 2069) ☐ EC  
IPP Rev: C As per Rev C 07-03-19 JLM ☐ ☐

| Component Item ID/<br>Item Name   | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6101-001<br><br>Saddle Billet |                        | Manufactured  | No          |                     |                  | 100             | Each               | 44.0000        | 1           | 4            |               |                |        |

*Handwritten:* 11-3-3

| Location         | Loc Qty | Loc Code |
|------------------|---------|----------|
| MAT40            | 44      |          |
| 61385            | 2       |          |
| 63537            | 2       |          |
| <del>64777</del> | 40      |          |

*Handwritten:* (x4)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

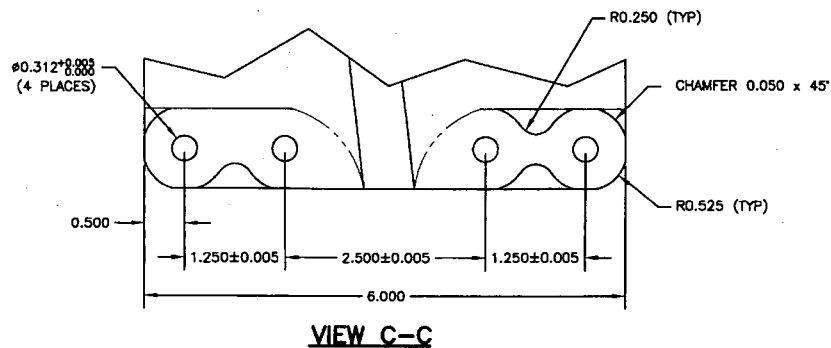
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

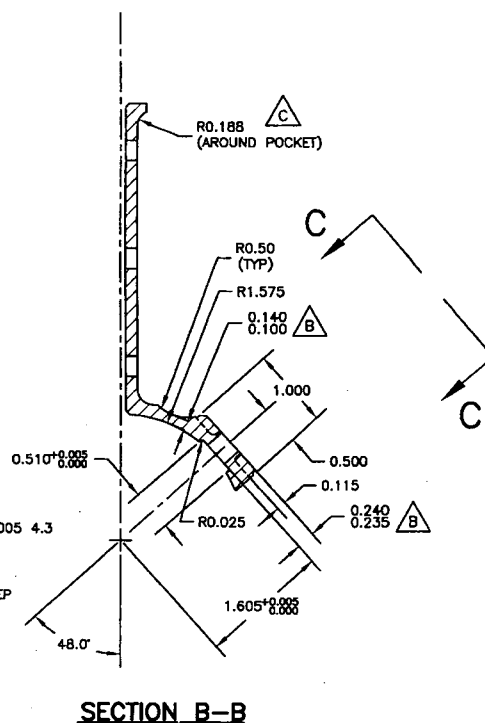




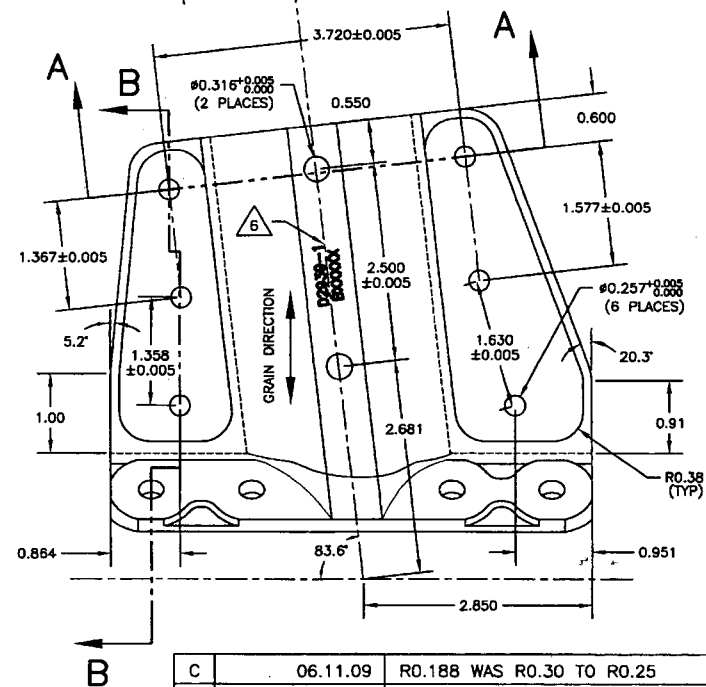
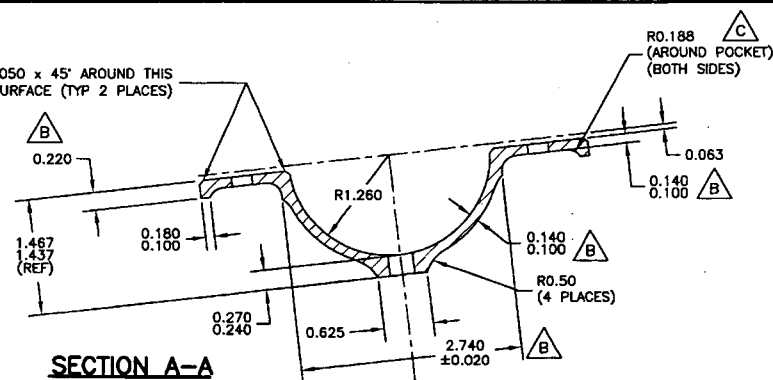
**D2939-1 LH SADDLE (SHOWN)**  
**D2939-2 RH SADDLE (OPPOSITE)**

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



CHAMFER 0.050 x 45° AROUND THIS SURFACE (TYP 2 PLACES)



|          |          |                                      |
|----------|----------|--------------------------------------|
| C        | 06.11.09 | R0.188 WAS R0.30 TO R0.25            |
| B        | 00.05.29 | CHANGED DEOMETRY AND MATERIAL        |
| A        | 99.11.12 | NEW ISSUE                            |
| DESIGN   | DRAWN BY | <b>DART</b> DART AEROSPACE USA, INC. |
| CHECKED  | APPROVED | DRAWING NO. D2939                    |
| DATE     | TITLE    | SADDLE INSIDE                        |
| 06.11.09 |          |                                      |

COPYRIGHT © 1999 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

REV. C

SHEET 1 OF 1

SCALE 2:3

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|  |  |                      |
|--|--|----------------------|
| DART AEROSPACE LTD                           |  | Work Order: 66385    |
| Description: 206 Saddle, Inboard, Right side |  | Part Number: D2939-2 |
| Inspection Dwg: D2939 Rev: C DSK: Rev:       |  | Page 1 of 1          |

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

| Dim           | Min   | Max   | Go/No Go Gauge | Record Actual Dimensions |       |       |       |   |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|---|
|               |       |       |                | 1                        | 2     | 3     | 4     | 5 |
| A             | 0.100 | 0.140 |                | .121                     | .120  | .119  | .121  |   |
| B             | 0.100 | 0.140 |                | .121                     | .124  | .124  | .126  |   |
| C             | 0.100 | 0.140 |                | .114                     | .115  | .112  | .110  |   |
| D             | 0.210 | 0.230 |                | .225                     | .225  | .225  | .224  |   |
| E             | 1.245 | 1.255 |                | 1.250                    | 1.250 | 1.250 | 1.250 |   |
| F             | 1.245 | 1.255 |                | 1.250                    | 1.250 | 1.250 | 1.250 |   |
| G             | 2.495 | 2.505 |                | 2.500                    | 2.500 | 2.500 | 2.500 |   |
| H             | 0.510 | 0.515 |                | .511                     | .511  | .513  | .511  |   |
| I             | 1.572 | 1.582 |                | 1.577                    | 1.577 | 1.577 | 1.577 |   |
| J             | 2.495 | 2.505 |                | 2.500                    | 2.500 | 2.500 | 2.500 |   |
| K             | 0.257 | 0.262 |                | .257                     | .257  | .257  | .257  |   |
| L             | 0.312 | 0.317 |                | .314                     | .314  | .314  | .314  |   |
| M             | 0.235 | 0.240 |                | .238                     | .238  | .238  | .238  |   |
| N             | 0.100 | 0.140 |                | .115                     | .115  | .115  | .113  |   |
| O             | 0.540 | 0.560 |                | .549                     | .549  | .549  | .549  |   |
| P             | 0.490 | 0.510 |                | .505                     | .505  | .505  | .505  |   |
| Q             | 3.715 | 3.725 |                | 3.720                    | 3.720 | 3.720 | 3.720 |   |
| R             | 2.720 | 2.760 |                | 2.741                    | 2.741 | 2.741 | 2.741 |   |
| S             | 0.240 | 0.270 |                | .256                     | .258  | .258  | .256  |   |
| T             | 0.100 | 0.180 |                | .125                     | .125  | .125  | .125  |   |
| U             | 1.625 | 1.635 |                | 1.630                    | 1.630 | 1.630 | 1.630 |   |
| V             | 1.362 | 1.372 |                | 1.367                    | 1.367 | 1.367 | 1.367 |   |
| W             | 0.316 | 0.321 |                | .316                     | .316  | .316  | .316  |   |
| X             | 1.250 | 1.270 |                | 1.260                    | 1.257 | 1.257 | 1.257 |   |
| Y             | 1.565 | 1.585 |                | 1.575                    | 1.575 | 1.575 | 1.575 |   |
| Z             | 0.178 | 0.198 |                | .188                     | .188  | .188  | .188  |   |
| AA            |       |       |                |                          |       |       |       |   |
| AB            |       |       |                |                          |       |       |       |   |
| AC            |       |       |                |                          |       |       |       |   |
| AD            |       |       |                |                          |       |       |       |   |
| Accept/Reject |       |       |                |                          |       |       |       |   |

|                         |                |
|-------------------------|----------------|
| Measured by: <i>al</i>  | Date: 11.3.3   |
| Audited by: <i>amf</i>  | Date: 11/03/03 |
| Prototype Approval: N/A | Date: N/A      |

| Rev | Date     | Change   | Revised by | Approved |
|-----|----------|--|------------|----------|
| A   |          | New Issue  | RF         |          |
| B   | 02.12.12 | Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B | KJ/RF      |          |
| C   | 07.03.21 | Revised per drawing revision C                                 | KJ/JLM     |          |
| D   | 07.11.23 | DT8695 A/B removed   | KJ/EC/DD   |          |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries